ULTRAHIGH TENSILE STRENGTH ELECTRIC RESISTANCE WELDED TUBE AND ITS PRODUCTION

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Abstract of **JP 9104921 (A)**

PROBLEM TO BE SOLVED: To produce an ultrahigh tensile strength steel tube high in tensile strength, excellent in hydrogen delayed fracture resistance and moreover excel lent in corrosion resistance. SOLUTION: A steel slab contg., by weight, 0.10 to 0.19% C, 0.01 to 0.5% Si, 0.8 to 2.2% Mn, 0.01 to 0.06% Al, 0.005 to 0.03% Nb and 0.0005 to 0.0030% B and contg. <=0.02% P, <=0.003% S, <=0.004% N and <=0.015% Ti is soaked at 1150 to 1300 deg.C and, thereafter, with the Ar3 point or above as the finishing temp., is coiled at 500 to 650 deg.C to form into a hot rolled steel strip, which is subjected to pickling and cold rolling, is subsequently soaked under heating to 800 to 900 deg.C in a continuous annealing furnace, is thereafter rapidly cooled and is moreover subjected to tempering treatment at 150 to 250 deg.C.; This steel strip is subjected to tube making at a width drawing rate Q satisfying 1000<=Q/(t/D)<2> <=3000 to obtain the objective ultrahigh tensile strength steel tube, where Q(%)=[the width of the steel sheet-&pi -(D-t)}/&pi (D-t)]× 100, t(mm): the sheet thickness and D (mm): the outer diameter of the steel tube.